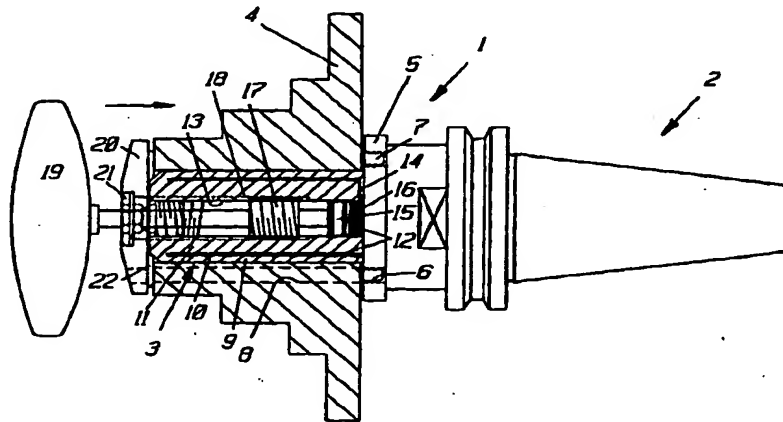


PCTWORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B23B 31/30	A1	(11) International Publication Number: WO 98/32562
		(43) International Publication Date: 30 July 1998 (30.07.98)
<p>(21) International Application Number: PCT/SE97/02195</p> <p>(22) International Filing Date: 19 December 1997 (19.12.97)</p> <p>(30) Priority Data: 9700236-4 28 January 1997 (28.01.97) SE</p> <p>(71) Applicant (for all designated States except US): ETP TRANSMISSION AB [SE/SE]; P.O. Box 1120, S-581 11 Linköping (SE).</p> <p>(72) Inventors; and (75) Inventors/Applicants (for US only): SAMELIUS, Anders [SE/SE]; ETP Transmission AB, P.O. Box 1120, S-581 11 Linköping (SE). ROSBERG, Niclas [SE/SE]; ETP Transmission AB, P.O. Box 1120, S-581 11 Linköping (SE).</p> <p>(74) Agents: HULTMAN, Olle et al.; Axel Ehmers Patentbyrå AB, P.O. Box 103 16, S-100 55 Stockholm (SE).</p>		<p>(81) Designated States: CN, JP, US, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).</p> <p>Published <i>With international search report.</i></p>

(54) Title: **HYDRAULIC PRECISION MANDREL**

(57) Abstract

A hydraulic precision mandrel for use in rotary machine tools and comprising a transition part (1) and a clamp body (3) which is fixedly connected thereto, onto which clamp body one or more tools can be slid and can be secured, and in which the clamp body (3) is formed as a hydraulic clamp bushing having a radially outwards expandable outer wall (9) and, radially inside said outer wall (9), an all around extending gap (10) which is filled with a hydraulic pressure medium (12), and in which the clamp body (3) is formed with an axial, central bore (13) provided in the clamp body (3), one or more cross channels (14) opening in the pressure medium gap (10), a piston (15) defining a pressure medium chamber (16) which is filled with pressure medium (12) and which is located at or adjacent the inner end of the clamp body bore (13), and a pusher means (17), for instance a threaded pusher piston which is within reach through the free end of the clamp body, for instance by means of a wrench (19) and which is adapted to move the piston inwards or outwards in the mandrel body bore (13) for pressurization and pressure releasing, respectively, of the pressure medium in the all around extending pressure medium gap (10). The mandrel comprises a rubber spring (20, 22) for resiliently pressing and radially straightening up the tool or tools (4) against a radial flange (5) of the transition part.

HYDRAULIC PRECISION MANDREL

The present invention generally relates to a mandrel which is preferably arranged for being mounted, with one end thereof, in a rotary machine tool, for instance in a lathe machine, a milling machine, a drilling machine etc. The mandrel can, alternatively and as desired, be releasably or fixedly mounted in the machine tool. In case the mandrel is of a releasable type it is mounted for instance by means of a mandrel cone part. The opposite end of the mandrel, for instance the free end thereof, should be formed for keeping one or more working tools or work pieces releasably secured thereon.

Various types of mandrels of said general type are known in the art. Such known mandrels generally are formed so that one or more of the exchangeable tools are secured in the direction of rotation of the mandrel by mechanical means like keys, splines and similar means, or by a heat press joint, and, in the direction for avoiding axial displacement, by means of nuts or screws. Such mechanical locking means do not give a perfect precision, and they may present radial play for the working tool, and it may often be difficult to provide a perfect centering of the mandrel with the tool, what in turn can give rise to unsatisfactory balancing and vibrations in the working tool and the tool machine depending thereon. It may also often be a difficult and time consuming operation to release the joint between the mandrel and the tools, especially in case the tools are mounted by heat press joints.

The present invention is intended to solve the above mentioned problems and disadvantages and to provide a precision mandrel for use in rotary machine tools, and which has, at its free end, a a clamp body (mandrel arbor), which is designed so that one or more tools can be slidably moved onto said arbor and can be secured thereon without the use of keys, splines and other mechanical locking means, which may be provided on the envelope surface of the clamp body, or without press joints, and in which a perfect centering and a perfect balancing of the tool or tools is obtained.

According to the invention said problem is solved in that the clamp body is formed as a hydraulic clamp bushing having a relatively thin outer wall and, radially inside of said outer wall, an all around extending pressure medium gap which is filled with a hydraulic pressure medium which, when being pressurized, makes said outer wall expand radially outwards thereby centering and clamp connecting the tool or tools on the clamp body.

For providing a safe rotary locking of the tools on the mandrel the tool

or tools, which are mounted closest to a transition part of the mandrel arranged between the two ends of the mandrel, can be formed with a couple of follower pins arranged to engage corresponding follower bores of the transition part.

- 5 For security reasons, for instance in case the operator happens to forget to activate the hydraulic system, the mandrel can be formed with a security ring, for instance a clamp ring formed with a rubber spring, which ring can be screw connected to the end of the clamp body, and which security ring foresees that the tool or tools engage the transition part before the hydraulic pressure medium is pressurized. The security ring can be connected to the
10 clamp body by means of a screw which is threaded into the clamp body, or the tool or tools can be formed with through bores for connection screws which can be secured in threaded bores of the transition part. It is, however, important that the tool should not be allowed to be finally locked by means of
15 mechanical forces, but that the tool should be centered and clamp connected by hydraulic means.

- For providing a pressurization of the pressure medium gap the clamp body (the expandable arbor) can be formed with a central bore having a pressure piston mounted therein, which defines a pressure chamber which,
20 over one or more cross channels is connected to the pressure medium gap, and in which the pressure medium of said chamber can be actuated by a piston which can be tightened by means of a wrench extending through the security means and through the bore of the clamp body, for instance a hexagon spanner, which directly engages the pressurization piston, and which
25 co-operates with inner threads of the central bore of the clamp body.

- Now the invention is to be described more closely with reference to the accompanying drawings, in which figure 1 discloses a hydraulic precision mandrel according to the invention in a partly cut open state before the tool has been mounted. Figure 2 correspondingly shows the hydraulic mandrel
30 after one or more tools have been mounted on the clamp body and while the hydraulic pressure medium of the pressure medium gap is being pressurized.

- The hydraulic mandrel shown in the drawings generally comprises a transition part 1 provided between the two ends of the mandrel, a mandrel cone part 2 for engagement in a corresponding conical bore of a rotary tool machine and a mandrel arbor or clamp body 3 for releasably connecting one or
35 more tools 4 and securing same on the clamp body 3. The transition part 1,

the cone 2 and the clamp body 3 provides an integral unity.

The transition part 1 and the mandrel cone 2 are of a type which is known per se and need not be described in detail. The cone is adapted for being introduced in a correspondingly conically formed cavity of a rotary machine tool, for instance a lathe machine, a milling machine, a drilling machine etc.

For making it possible to connect one or more rotary tools 4 on the mandrel the clamp body (expandable arbor) is formed with a smooth cylindrical outer surface. If wanted said outer surface can be formed with different (stepped) diameters for centering and clamp connecting tools/work pieces having different fitting diameters. The tools 4 are slid into contact with a projecting flange 5 of the transition part 1. Said flange 5 can be formed with a pair of bores 6 in which follower pins 7 of the tool located closest to the flange 5 can engage for providing a rotary engagement of the tools. Alternatively the tools can have through bores 8 (see the lower part of figure 2) through which clamp screws can be introduced and can be threaded into the bores 6 of the flange 5.

The clamp body 3 is formed as a hydraulic clamp bushing, and to that end it has a relatively thin, radially outwards expandable outer wall 9 and an all around extending narrow gap 10 facing the radially inner thereof located supporting body 11, which gap 10 is filled with a hydraulic pressure medium 12, which upon pressurization of the pressure medium makes said outer wall 9 expand radially outwards thereby centering, balancing and clamp connecting the tool or tools 4 which have been slid onto the clamp body 3.

For making it possible to pressurize the pressure medium 12 of the gap 10 the clamp body is formed with an axial bore 13 which, at the inner end thereof, has one or more cross channels 14 opening into the pressure medium gap 10. At the inner end of the axial bore 13 of the arbor 3 there is a displaceable piston 15 defining a pressure chamber 16, which is filled with a pressure medium 12. At the axially outer end the piston 15 has a pushing means 17 which co-operates with inner threads 18 of the bore 13. The pusher means 17 has an inner connection bore for a wrench 19, for instance a hexagonal wrench of T-handle type. When the pusher 17 and thereby also the pressure piston 15 is tightened by means of the wrench 19 pressure medium is forced from the pressure medium chamber 16, through the cross channel 14 and into the all around extending pressure medium gap 10 thereby

providing a radial expansion of the outer wall 9 and a centering and clamp connecting of the tools 4 on the clamp body 3. When untightening the pusher means 17 the outer wall 9 regains its non-expanded shape and the tools 4 become released.

- 5 For providing an accurate connection of the tools, and for eliminating any type of wobbling thereof it is important that the tools are pressed against the flange 5 of the transition part 1, and to that end the apparatus comprising a pressure ring 20 which can be screwed into contact with the end of the clamp body 3 by means of a tap screw 21 which engages inner threads 18 of
10 the mandrel bore 13, and which with the head thereof forces the pressure ring 20 in the direction towards the transition part 1. The pressure ring 20 preferably can have a rubber spring 22 enclosed therein for providing a resilient forcing of the tools 4 against the flange 5. Both the pressure ring 20 and the screw 21 are formed with axial through bores, so that the wrench 19
15 can be introduced in the pusher means 17 thereby providing a pressurization and a pressure releasing, respectively, of the hydraulic pressure medium of the pressure medium gap 10.

- The mounting of the tools is simply made in that it is firstly foreseen that the pressure medium gap 10 of the clamp body 3 is released from
20 pressure; one or more tools are slid onto the clamp body 3 and into contact with the flange 5 of the transition part 1, and so that the follower pins 7 engage the corresponding bores 6 of said flange 5; the pressure ring 20 is tightened by means of the tap screw 21, so that the tools are resiliently pressed against the flange 5 by the action of the rubber spring 22; a wrench
25 19 is introduced through the bore of the screw 21 and the pressure ring 20 and into the wrench receiving bore of the pusher means 17, and said pusher means is tightened by a certain force, whereupon the tools are centered and clamp connected by the thin outer wall 9.

The releasing of the tool/tools follows in the opposite order.

- 30 As mentioned above the pressure ring can alternatively be screw connected by means of two or more tap screws extending axially therethrough the pressure ring 10 and through the tools, and which can be threaded into the bores 6 of the flange 5.

REFERENCE NUMERALS

	1	transition part	12	pressure medium
	2	mandrel cone	13	axial bore
	3	clamp body	14	cross channel
5	4	tool/tools	15	pressure piston
	5	flange	16	pressure chamber
	6	bore (of the flange)	17	pusher means
	7	follower pin	18	threads
	8	bore (of the tool/tools)	19	wrench with handle
10	9	outer wall	20	pressure ring
	10	gap	21	screw
	11	supporting body	22	rubber spring

C L A I M S

1. Mandrel intended for use in rotary machine tools and comprising a transition part (1) and a clamp body (3) connected thereto, onto which clamp
5 body one or more tools can be slid and on which said tool/tools can be secured, and in which the clamp body (3) is formed as a hydraulic clamp bushing having a thin, smooth outer wall (9) and, radially inside thereof, a gap (10) which is filled with a hydraulic pressure medium (12) which, when pressurized, makes the outer wall (9) expand radially outwards, characterized
10 in that the mandrel is formed with means inside the mandrel body (11) for pressurizing the pressure medium (12) in the pressure medium gap (10), which means comprises an axial, central bore (13) in the mandrel body (11), one or more cross channels (14) opening in the pressure medium gap (10) at a place adjacent the end of the mandrel body bore (13), a piston (15) defining a
15 pressure medium chamber (16) which chamber is filled with pressure medium (12) at or adjacent the inner end of the mandrel body bore (13), and a pusher means (17) which is actuatable from outside through the free end of the clamp body, and which is arranged for displacing the piston (15) inwards or outwards in the mandrel body bore (13) for pressurizing and releasing
20 pressure, respectively, of the pressure medium in the all around extending pressure medium gap (10).

2. Mandrel according to claim 1, characterized in that the pusher means is a rotatable piston (17) which is threaded and engages inner threads (18) of the mandrel body bore (13) and which is formed with a coupling bore
25 for engagement of a wrench (19) introduced through the mandrel body bore (13) and used for tightening an untightening, respectively, of the piston (15, 17).

3. Mandrel according to claim 1 or 2, characterized in that the transition part (1) has a radial flange (5) at the connection end for the clamp
30 body, and in that the mandrel, at the free end of the clamp body (3), has a pressure ring (20) adapted to press and to straighten up the tool or tools (4) against the flange (5) before the tools are clamp connected by pressurization of the pressure medium gap (10) of the clamp body (3).

4. Mandrel according to claim 3, characterized in that the pressure ring
35 (20) is secured to the mandrel by means of a central tap screw (21) which is connected to the threaded bore (18) of the clamp body (11) by means of

screw threads.

5. Mandrel according to claim 3, characterized in that the pressure ring (20) is secured to the mandrel by means of a pair of screws extending through the tool or tools (4), which screws are threaded into the transition part (1).

5 6. Mandrel according to claim 3, 4 or 5, characterized in that the tool (4), or the tool located closest to the transition part (1) is formed with a pair of follower pins (7) arranged to engage corresponding follower bores (6) of the transition part.

10 7. Mandrel according to any of claims 3 - 6, characterized in that the pressure ring (20) is formed with a rubber ring (22) which is partly embedded in the pressure ring (20) and which acts as a rubber spring when the tool or tools is/are pressed against the flange (5) of the transition part (1).

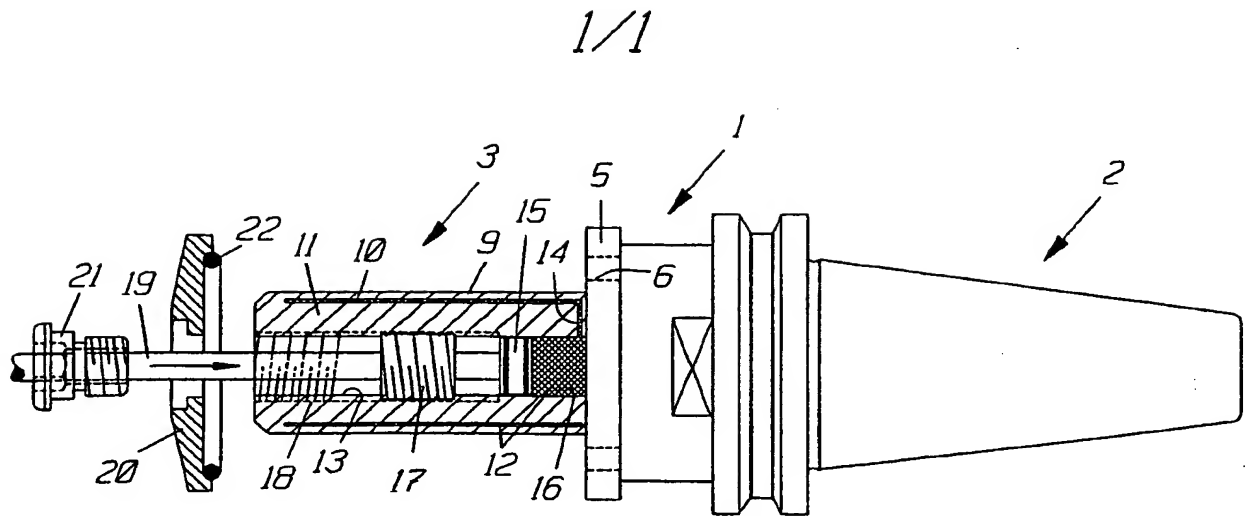


Fig. 1

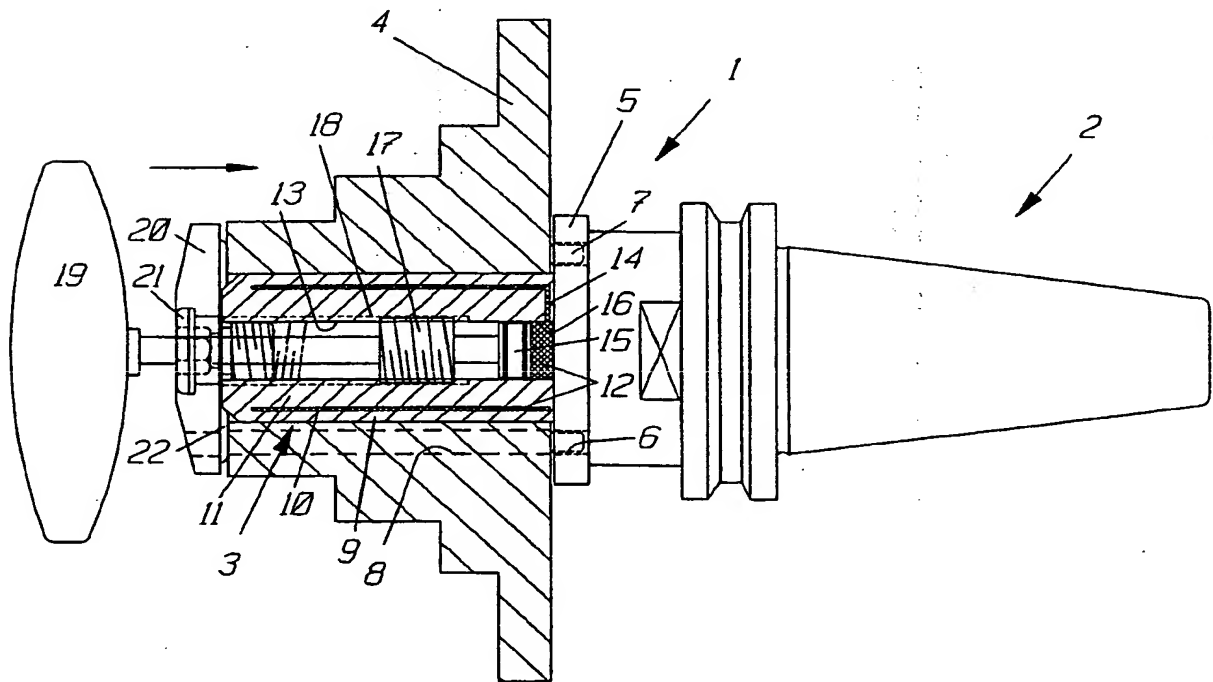


Fig. 2

1

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 97/02195

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: B23B 31/30

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: B23B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EDOC, WPI

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5174585 A (ERKKI), 29 December 1992 (29.12.92), figure 5A	1-7
	--	
X	WO 95 29029 A1 (SPIREX TOOLS AB), 2 November 1995 (02.11.95), figure 3, abstract	1,2,4,7
	-- -----	

☐ Further documents are listed in the continuation of Box C. ☒ See patent family annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

Date of mailing of the international search report

12 March 1998

17 -03- 1998

Name and mailing address of the ISA/
Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM
Facsimile No. +46 8 666 02 86

Authorized officer

Tycht Beckman
Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT

Information on patent family members

03/02/98

International application No.

PCT/SE 97/02195

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 5174585 A	29/12/92	AU 6337990 A	28/04/91
		DE 9017016 U	12/09/91
		DE 69031837 D	00/00/00
		EP 0495795 A,B	29/07/92
		JP 5500336 T	28/01/93
		US 5251912 A	12/10/93
		US 5255928 A	26/10/93
		US 5386769 A	07/02/95
		WO 9104814 A	18/04/91
<hr/>			
WO 95029029 A1	02/11/95	NONE	
<hr/>			

PCT

WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



014

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B23B 31/30	A1	(11) International Publication Number: WO 98/32562
		(43) International Publication Date: 30 July 1998 (30.07.98)

(21) International Application Number: PCT/SE97/02195
(22) International Filing Date: 19 December 1997 (19.12.97)

(30) Priority Data:
9700236-4 28 January 1997 (28.01.97) SE

(71) Applicant (for all designated States except US): ETP TRANSMISSION AB [SE/SE]; P.O. Box 1120, S-581 11 Linköping (SE).

(72) Inventors; and

(75) Inventors/Applicants (for US only): SAMELIUS, Anders [SE/SE]; ETP Transmission AB, P.O. Box 1120, S-581 11 Linköping (SE). ROSBERG, Niclas [SE/SE]; ETP Transmission AB, P.O. Box 1120, S-581 11 Linköping (SE).

(74) Agents: HULTMAN, Olle et al.; Axel Ehmers Patentbyrå AB, P.O. Box 103 16, S-100 55 Stockholm (SE).

(81) Designated States: CN, JP, US, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).

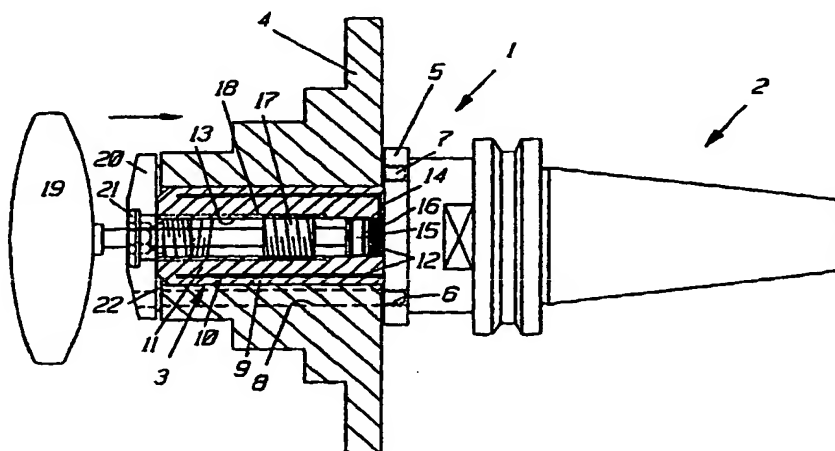
Published

*With international search report.
With amended claims.*

Date of publication of the amended claims:

18 February 1999 (18.02.99)

(54) Title: HYDRAULIC PRECISION MANDREL



(57) Abstract

A hydraulic precision mandrel for use in rotary machine tools and comprising a transition part (1) and a clamp body (3) which is fixedly connected thereto, onto which clamp body one or more tools can be slid and can be secured, and in which the clamp body (3) is formed as a hydraulic clamp bushing having a radially outwards expandable outer wall (9) and, radially inside said outer wall (9), an all around extending gap (10) which is filled with a hydraulic pressure medium (12), and in which the clamp body (3) is formed with an axial, central bore (13) provided in the clamp body (3), one or more cross channels (14) opening in the pressure medium gap (10), a piston (15) defining a pressure medium chamber (16) which is filled with pressure medium (12) and which is located at or adjacent the inner end of the clamp body bore (13), and a pusher means (17), for instance a threaded pusher piston which is within reach through the free end of the clamp body, for instance by means of a wrench (19) and which is adapted to move the piston inwards or outwards in the mandrel body bore (13) for pressurization and pressure releasing, respectively, of the pressure medium in the all around extending pressure medium gap (10). The mandrel comprises a rubber spring (20, 22) for resiliently pressing and radially straightening up the tool or tools (4) against a radial flange (5) of the transition part.

AMENDED CLAIMS

[received by the International Bureau on 28 May 1998 (28.05.98);
original claims 1-7 replaced by amended claims 1-7 (2 pages)]

1. Mandrel apparatus for making it possible to clamp connecting tools
5 (4) in rotary machine tools and comprising an integral unit formed with means for mounting of the apparatus in the machine tool, a transition part (1) and a clamp body (3) for clamp connecting said tool (4), characterized

- in that the apparatus is formed as a mandrel, in which the clamp body
(3) is formed as a hydraulic clamp bushing having a thin, smooth outer wall (9)
10 onto the outer surface of which one or more tools can be slid and can be secured, and an inner solid mandrel body (11), and a gap (10) provided between said thin outer wall (9) and the mandrel body (11), which gap is filled with a hydraulic pressure medium (12) which, when pressurized, makes the outer wall (9) expand radially outwards thereby clamp connecting said tool or
15 tools (4),

- in that the mandrel body (11) at the interior thereof is formed with means (15, 17) for pressurization of the pressure medium (12) in the pressure medium gap (10) and comprising an axial, central bore (13) in the mandrel body (11), which can be reached from the free end of the apparatus and
20 which contains a pressure piston (15) defining a pressure medium chamber (16) which is filled with pressure medium (12), and which communicates with the pressure medium gap (10) of the clamp body (3) over one or more cross channels (14) at a place close to the mandrel body bore (13),

- and in that the pressure piston (15) is arranged for being actuated by
25 a pusher means (17) which can be reached from outside the apparatus through the free end of the clamp body (3), and which is arranged for displacing the piston (15) inwards or outwards in the mandrel body bore (13) for pressurizing and for releasing the pressure, respectively, of the pressure medium in the all around extending pressure medium gap (10).

30 2. Mandrel apparatus according to claim 1, characterized in that the pusher means is a rotatable piston (15, 17) which is threaded and engages inner threads (18) of the mandrel body bore (13) and which is formed with a coupling bore for engagement of a wrench (19) adapted to be introduced through the end of mandrel body bore (13) and used for tightening an
35 untightening, respectively, of the piston (15, 17).

3. Mandrel apparatus according to claim 1 or 2, characterized in that

the transition part (1) has a radial flange (5) at the connection end for the clamp body (3), and in that the mandrel, at the free end of the clamp body (3), has a pressure ring (20) adapted to provide a press engagement and to straighten up the tool or tools (4) against the flange (5) before the tools are clamp connected by pressurization of the pressure medium gap (10) of the clamp body (3).

4. Mandrel apparatus according to claim 3, characterized in that the pressure ring (20) is secured to the mandrel by means of a central tap screw (21) which is connected to the threaded bore (18) of the clamp body (11) by means of screw threads.

5. Mandrel apparatus according to claim 3, characterized in that the pressure ring (20) is secured to the mandrel by means of a pair of screws extending through the tool or tools (4), which screws are threaded into the transition part (1).

6. Mandrel apparatus according to claim 3, 4 or 5, characterized in that the tool (4), or the tool located closest to the transition part (1) is formed with a pair of follower pins (7) arranged to engage corresponding follower bores (6) of the transition part.

7. Mandrel apparatus according to any of claims 3 - 6, characterized in that the pressure ring (20) is formed with a rubber ring (22) which is partly embedded in said pressure ring (20) and which acts as a rubber spring when the tool or tools is/are pressed against the flange (5) of the transition part (1).